

Work Order ID 66621

Wednesday, February 23, 2011 8:07:01 AM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 2/23/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *M*

Date: 11-02-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

8-103/23

JG BG 11-3-21 (10)

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M108436*

3-Grind End Plate flush

M115938

11-03-09 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				10	0	BE11/03/10	
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				410	24		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				96/AE	11-03-11	10	

Dart Aerospace Ltd

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11.03.16

10

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

11.03.17

10

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod 11108436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

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Reference:

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool

**Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

190

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

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Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 11:00 OVEN TEMPERATURE: 320 °F FINISH TIME: 11:30	0.00 0.00							1044 BR/m.f 11/03/22
230  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M116002 Memo	0.00							X106M 11 11/03/22
240  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							11/3/23 51 100

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Required Date: 3/18/2011 Req'd Qty: 10.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  Packaging	Pick Kit	0.00							
	Memo	0.00							
260  QC	QC4- 100% Inspect kits for completeness	0.00							
	Memo	0.00							
270  Packaging	Packaging	0.00							
	Memo	0.00							
	Identify and pack for shipping as per PPPD350-591-311 Location: _____								

4/3/21 SP 100

8 u103/23

6
4H

4/13/23 (10)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/23

K11-03-23
10

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W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, February 23, 2011 8:07:08 AM

Page 1

Work Order ID: 66621

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH





Start Date: 2/23/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
 by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 		Manufactured	No			110	Each	0.0000	1	10			
Step													
D3067-1 		Manufactured	No			110	Each	128.0000	1	10			
End Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA 866133		128				10			
				65969		128							
D3219-1 		Manufactured	No			110	Each	135.0000	2	20			
Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		135							
				63551		19				20			
				66133		116							
D3066-1 		Manufactured	No			180	Each	6.0000	2	20			
Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA 866131		6				20			
				65072		6							

11.03.08 866624

11.03.09

10
20
11.03.09

20
20
11.03.16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 2/23/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

2,263.000

16

160



Rivets

Location

Loc Qty

Loc Code

ST321

2263

113368

38

114181

11

114718

2

115573

70

115640

31

116022

4

116188

1500

116712

607

D3065-041

Manufactured

No

180

Each

57.0000

1

10



Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA

57

63554

17

66149

40

D3067-1

Manufactured

No

180

Each

128.0000

1

10



End Plate

Location

Loc Qty

Loc Code

WA

128

65969

128

10

Wednesday, February 23, 2011 8:07:09 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 2/23/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

AN3-35A

Purchased No

250 Each

102.0000

2 20

Bolt

Location

Loc Qty

Loc Code

ST353

102

116191

100

116704

2

D3235-1

Manufactured No

250 Each

0.0000

2 20

Mounting Lug

D3278-041

Manufactured No

250 Each

1.0000

1 10

Support Assembly

Location

Loc Qty

Loc Code

ST471

1

63553

1

AN960JD416

NAS1149D0463J

Purchased No

250 Each

30.0000

16 160

Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 2/23/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

34.0000



Washer



4 40

M116702 11/3/21

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN5-36A

Purchased

No

250

Each

157.0000



Bolt



2 20

11/3/21

Location

Loc Qty

Loc Code

ST341

157

114292

1

116191

6

116549

50

116704

100

D2618

Manufactured

No

250

Each

83.0000



Bushing



2 20

11/3/21

B66942

Location

Loc Qty

Loc Code

ST019

83

65071

3

66132

80

3

11

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 2/23/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00



D2230-3

Manufactured No

250

Each

6.0000



4

40

B68936 11/3/238

Lug

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST476 \

2

55452

2

D2856-400

Manufactured No

250

f

188.3980



1.2

12

11/3/218

Abraison Strip

Location

Loc Qty

Loc Code

ST403

188.3980421

56626

0.00004211

59920

43.381

63735

145.017

*** cut (2) at 7.20" (D2856-400-720) ***

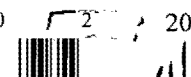
MS2T042L3

Purchased No

250

Each

2,704.000



2

20

11/3/218

Nut

Location

Loc Qty

Loc Code

ST300

2704

110844

4

114784

9

115835

191

116391

900

116540

800

116549

800

20

Dart Aerospace Ltd

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Start Date: 2/23/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

486.0000



Bolt



11/3/11

Location

Loc Qty

Loc Code

ST357

486

116191

7

116669

179

116786

300

Purchased

No

250

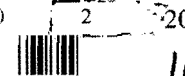
Each

1,030.000

MS210421:5



Nut



11/3/11

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1004

115594

308

116105

496

116548

200

Purchased

No

250

Each

5,182.000

MS210421:4



Nut



11/3/11

100

Location

Loc Qty

Loc Code

ST300

5182

1123143

2

115589

10

115621

20

116188

3150

116823

2000

80

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Start Date: 2/23/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

AN960JD10

NAS1149D0363J Purchased

No

250

Each

24.0000

4

40



Washer



1116583 11/3/11 SP 100

Location

Loc Qty

Loc Code

ST	6
107715	6
ST335	18
105792	2
112279	16

W/O:		WORK ORDER CHANGES					
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DART

DESIGN <i>90</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *44621*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

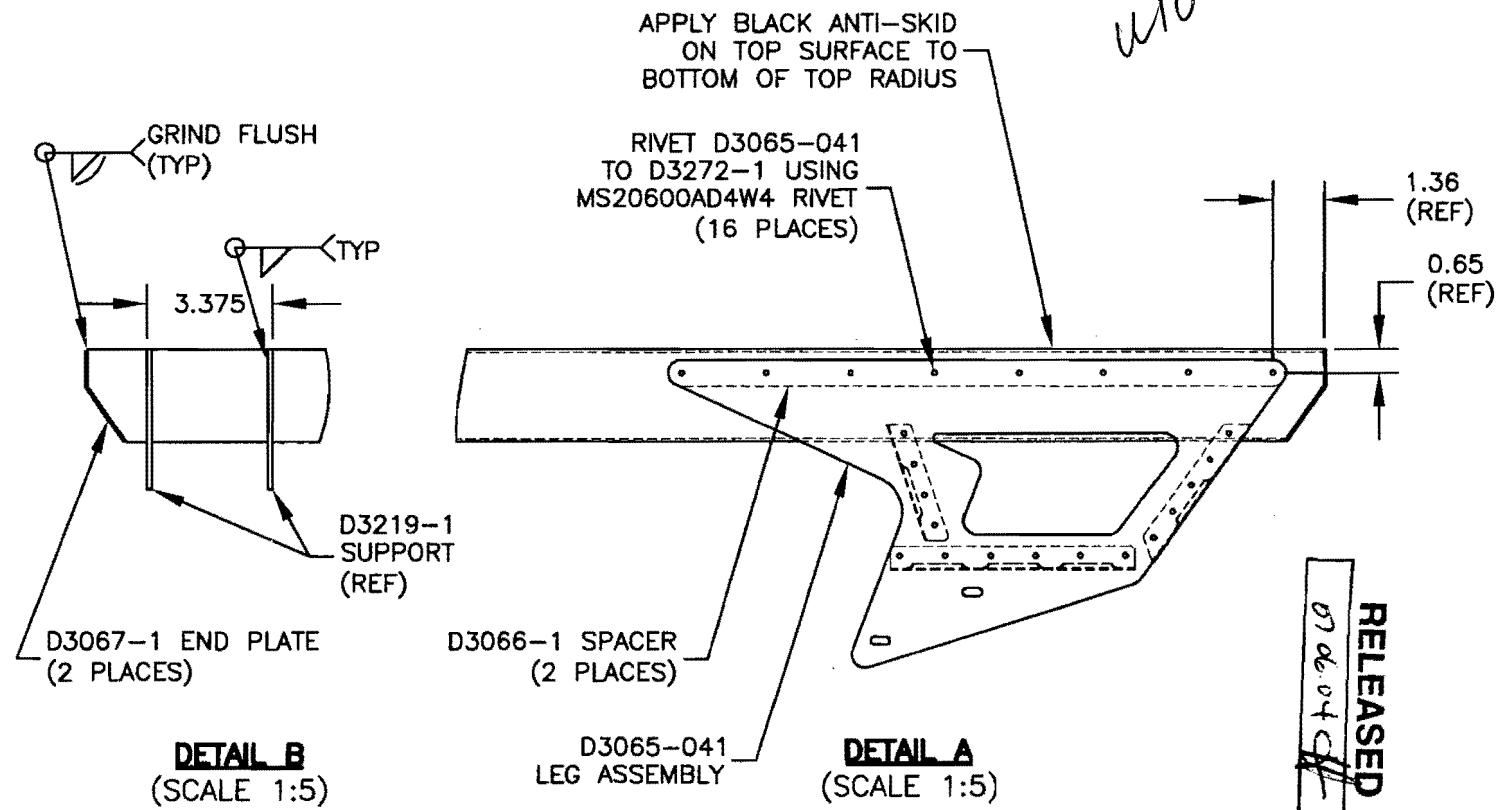
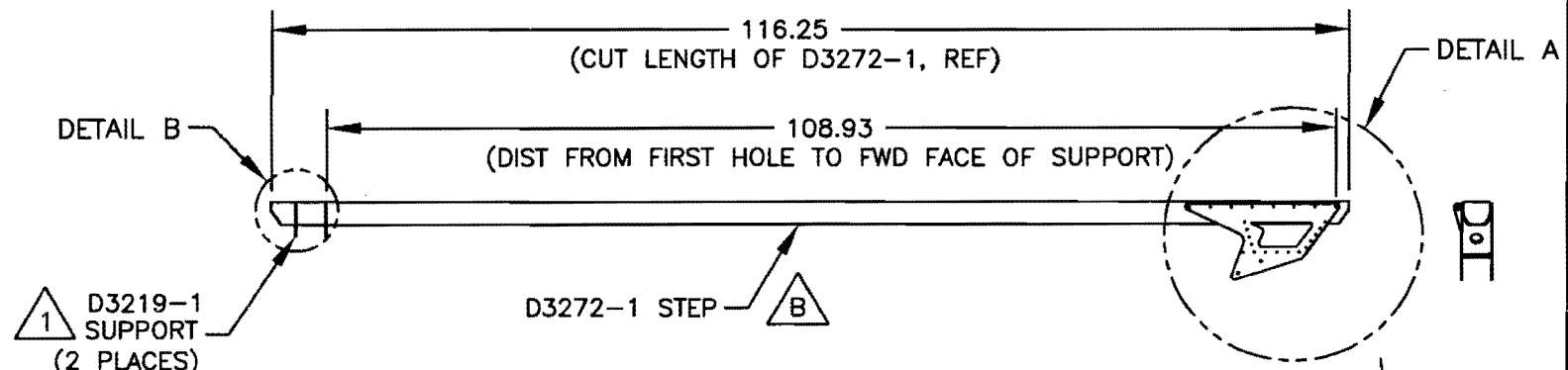
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	SHEET 2 OF 3	SCALE
07.05.18	D3272	STEP ASSEMBLY, HI LONG	1:20



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

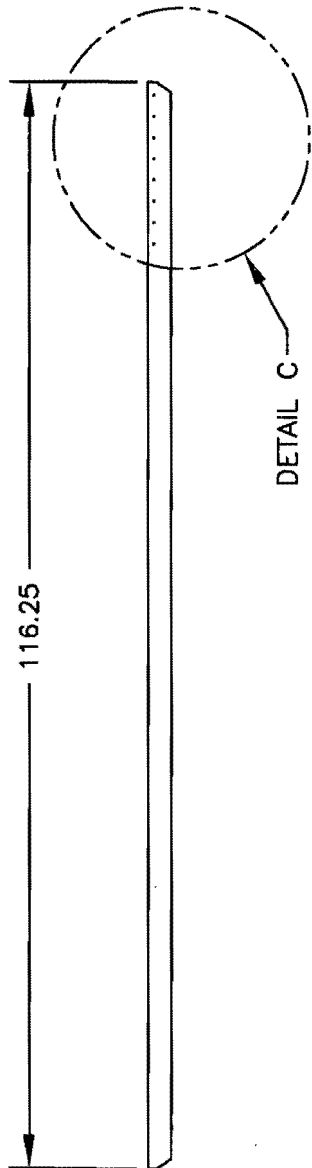
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

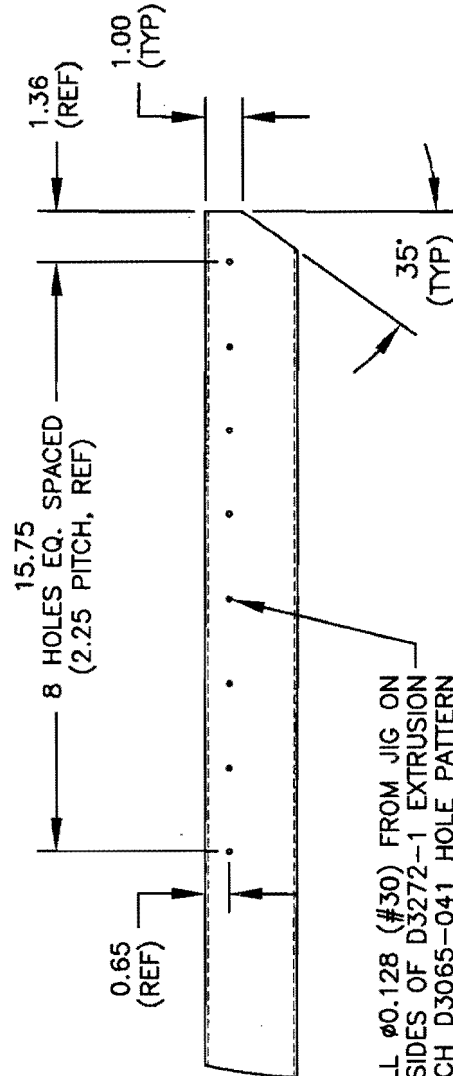


DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)

18mm
W/b



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	*WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	*NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

